Work Orde March-01-13 1:		937		*970	337*		20 0.0 10.00 10.00 10.00				Page 1
Revision ID:	D3913-041 Long Basket E	Base Assemby, 350	Latel	Accept	*N900	040	100)* :	Setup Star	i Vi	S1* S2*
Start Date: Required Date: Reference:	3/07/13 3/12/13	Start Qty: 1.0 Req'd Qty: 1.0		1* 1*	Cust Item 1 Customer:	ID:					
Approvals:	Process Pla	n: ML5	Date: <u>/3</u> -	73-04 Tooling:	D	ate:		I	Run Star	"[V]	R1*
				•	D	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3913	В		-2							per his	
D4020	A		128t								
*100 *100* Large Fab Large Fab		Large Fab Memo 1- asser	mble ribs, weld as perpect before welding n	0.00 r dwg D3913 using DT9610A	•			CC	/3-	4-23	·
÷				d tack weld all mesh on basket as ary and trim to clear fasteners hole							
			hinge (3) and Mount e lid to locate hinge ar	ing brackets as per dwg D3913 ad bracket***							•
		4- Weld	d D4672-1 blanking p	lates as per dwg							
*110 *110*		QC9- Inspect visual	per QSI004- Fusion						13.0	-1-23	DAG
QC		Memo		0.00						-	8 3 3 ·

Quality Control

								DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON-	-CONFORI	MANCE / UP		QA Closed:	Date:	
Work Order:				DISPOSITION			AGAINST DEI	PARTMENT	/PROCESS	
Work Order.				Rework	7 	Skid-tube	Crosstube		Water Jet	Engineering
Part No				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	· · · · · · · · · · · · · · · · · · ·			Use-as-is	Therr	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No				Work Order Update		Large Fab	Composite		Supplier	
							· · · · · · · · · · · · · · · · · · ·			
Root				Description of work order update	Initial	1	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data										
quip/Tooling									!	
Operator	_									
Material										
Setup										
Other										·
Process										
Supplier										
Fraining	_									
Inapproved	1	1	i							

	FAULT CATEGORY										
Landing	Gear	General				_					
	Bending	Bend		Grain		Ovalized	Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld				
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved					
	Heat Treat	Countersink		Mislabeled		Positioned Wrong					
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other				
	Ripples in Bend	Drill Holes		Offset							
	Torque Waves in Extrusion		Out of Calibration								
	Turning Sequence		Out of Sequence								
	Wave/Twist in Tube	Folio		Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		7937		*979	37*						Page 2
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900	040	100) * s	Setup Star	IV	S1* S2*
Start Date: Required Date: Reference:	3/07/13 3/12/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling:	Date:			F	Run Sta	171	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	Operation		eteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp OG OG
125- *195* HandFinish		Pressure Wash per QS10 Memo	05 4.3	0.00	-				Al	7/3°	423

Hand Finishing

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPDATE				
											QA Closed:	Date	
Work Orde	or.					DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS	
WOIK OIG	-					Rework	1		Skid-tube Cross	tube]	Water Jet	Engineering
Part N	No.					Scrap			Machining Smal	· ·	4	d. Eng. Coor.	Quality
	_					Use-as-is]	ŧ	~ —	hing	Rec/Sto	re/Packaging	Other
NCR I	۷o. ₋	<u> </u>				Work Order Update]		Large Fab Comp	osite	j	Supplier	
Root					Descri	ption of work order update	Π	Initial	Action		Sign &	4	
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш										1		
Equip/Tooling	Ш												
Operator	Ш												
Material	Ш							:					
Setup	Ш												
Other	Ш												
Process	Ш												
Supplier	Ш											<u> </u> 	
Training	Ш						İ		:				
Unapproved											<u></u>		
							AUL	T CATE	GORY				
Landi	ng G	iear				General	_	7		_	٦	_	7
	-	Bending				Bend		Grain		<u> </u>	Ovalized	_	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re	ļ_	Over/Under	 	Temperature/Cure
	Ш	Cracks				Broken/Damaged	Inspection Incomplete					ct	Weld
	Ш	Crushed/	Crimped.			Burrs	_	-{	ions Incomplete/Unclear	$oxedsymbol{oldsymbol{oldsymbol{eta}}}$	Part Lost/M	issing	Wrong Stock Pulled
****	Ш	Cuffs				Contamination		Mainte		<u> </u>	Part Moved		
* * * *		Heat Trea	t			Countersink		Mislabe		<u></u>	Positioned \	_	¬
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i	L	Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes	ill Holes Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		7937		*979	37*							Page 3
Item ID: Revision ID:	D3913-041	Base Assemby, 350		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	3/07/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					"IN	5 /"
Approvals:	Process Pl QC:	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating		coat 1ST COAT: START TIM OVEN TEM FINISH TIM ********** 2ND COAT START TIM	AE: AE: AE: AE: AE: AE: AE: AE:	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder		Tool#	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
*140 *140*		QC3- Inspect Part Finish	V - /	0.00		,			0	13	4-2:	3. 200

Quality Control

NCR:	Yes	/	No

DQA: _____ Date: ___

NCR: Y	es / No				WORK ORDER NON-	CON	-OKIV	MANCE / UPDATE	QA Closed:	Date:	
Mark Orda					DISPOSITION		•	AGAINST DE	PARTMENT,	PROCESS	÷
Work Orde Part N					Rework Scrap		N	Skid-tube Crosstube Small Fab	1	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update			noforming Finishing Large Fab Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descr	iption of work order update	Ini	itial	Action	Sign &		
Cause	Date	te Step Qty or Non-conformance Chief Eng Description						Description	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material											
etup		,		1							
Other	.	-				Ì					
Process				·	•				ļ		
Supplier						1					
raining					•						
Jnapproved			<u> </u>								<u> </u>
						AULT	CATE	GORY			
Landir 1	ng Gear			_	General	\Box		ſ—	1,	_	Pressure/Forced
4"	Bendin	-			Bend		rain	 	Ovalized	+-lauauaa	-
		Not Conce	ntric to	O/S	BOM/Route	 	lardwa	 	Over/Under		Temperature/Cure Weld
	Cracks			<u> </u>	Broken/Damaged	_		on Incomplete	Part Incorre	 	
		d/Crimped		-	Burrs	\vdash		ions Incomplete/Unclear	Part Lost/M	issuig	Wrong Stock Pulled
	Cuffs Contamination						⁄Iainte ∕Iislabe	enance	Part Moved	Aluana	
	Heat Treat Countersink								Positioned V		Johns
}	 	ion Strip ir	1 Tube	L	Cut Too Short				Other		
1	→ ``	in Bend		_	Drill Holes	—	Offset	[.]		·	
		Waves in		n _	Drawing			Calibration			<u> </u>
1		Sequence		<u>_</u>	Finish	Out of Sequence					
ì	Wave/1	wist in Tu	be	l	Folio Outside Dimensions						

Work Orde March-01-13 1:		937		*979	Page 4						
Revision ID:	D3913-041 Long Basket l	Base Assemby, 350		Accept	*N900	040	100*	Set	up Start Stop	14.7	* *
Start Date: Required Date: Reference:	3/07/13 3/12/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:					
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		Rui	n Start Stop	"INK	
Sequence ID/ Work Center II 150 *150* HandFinish Hand Finishing	0	Operation Description Assemble as per dwg Memo Pick Kit	•	Set Up/ Run Hours 0.00	Tool ID	Tool #		Qty ·	Qty	Reject Ins Number Sta	mp
*160 *160* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00	3424						
170 *170* Packaging		Identify as per dwg & Sto	ock Location DMO3	0.00	97939		•		ø.	BV 13-4-	23.

Packaging

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR!	MANCE / UPI	DATE		•		,	
											•	QA Closed:	Da	ite:	
Work Ord						DISPOSITION				AGAINST I	DE	PARTMENT	/PROCESS		
WORK Ord	er					Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part I	Vo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	\vdash	Quality
	•					Use-as-is	1		noforming	Finishing		ł	e/Packaging	\perp	Other
NCR I	No.					Work Order Update			Large Fab	Composite			Supplier		
À															
Root						ption of work order update	1	Initial		ion		Sign &		İ	
Cause	.	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling			ļ												
Operator	Ш														
Material	Щ														,
Setup	Ш						1								
Other	$\vdash \vdash$						ŀ								
Process	Н														
Supplier	Н														
Training	\vdash														
Unapproved			1				<u> </u>	T CATE	CORY			<u>l</u>	<u> </u>		
Landi		`~~				General F	AUL	LICATE	3081						
Lanui	$\overline{}$	Bending	-			Bend		Grain		ļ		Ovalized			Pressure/Forced
		Centre No	nt Conce	ntric to 1	7/5	BOM/Route	\vdash	Hardwa	re	ŀ		Over/Under	tolerance	-	Temperature/Cure
	Н	Cracks	or concer	Title to	^{5/3} ⊢	Broken/Damaged	-	4	ion Incomplete			Part Incorre			Weld
	ш		Crimnad		-	Burrs	\vdash	- 1 `	·	Inclear		Part Lost/Mi		\vdash	Wrong Stock Pulled
					Contamination	Instructions Incomplete/Unclear Part Lost/Missing Part Moved			T						
	Н	Heat Trea	ıt		<u> </u>	Countersink	Mislabeled Positioned Wrong								
	Inspection Strip in Tube Countersink Countersink Cut Too Short					Misread						Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

er ID 9' :51:14 PM	7937		*970				Page 5				
			N900040100)	-	IV		<u> </u>	
3/07/13 : 3/12/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				IV		
Process P	lan:	Date:	Tooling: SPC (Y/N):				F		17	R1*	
D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
	D3913-041 Long Basket 3/07/13 : 3/12/13 Process P QC:	D3913-041 Long Basket Base Assemby, 350 3/07/13 Start Qty: 1.00 Req'd Qty: 1.00 Process Plan: QC: Operation Description QC21- Final Inspection -	D3913-041 Long Basket Base Assemby, 350 3/07/13	D3913-041 Accept	D3913-041	D3913-041	D3913-041	D3913-041	D3913-041	D3913-041	D3913-041

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of Baysy

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	AANCE / UPDATE				
											QA Closed:	Date	:
Work Orde	٦r.					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
WOIK OIG	-					Rework	7		Skid-tube Crosstu	be]	Water Jet	Engineering
Part N	No.					Scrap	1		Machining Small F	_	Pro	d. Eng. Coor.	Quality
	-		· · · ·			Use-as-is]	Therm	noforming Finishi	ng	Rec/Sto	e/Packaging	Other
NCR N	No.			<u>-</u> .		Work Order Update]		Large Fab Compos	ite		Supplier	
Root			[Descri	ption of work order update		Initial	Action	······································	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data				!									
Equip/Tooling				:								,	
Operator													
Material	Ш												1
Setup													
Other											-		
Process													
Supplier													
Training	Ш												
Unapproved			<u></u>	<u> </u>								<u> </u>	<u> </u>
							AUI	LT CATE	GORY				
Landi						General	_	7			1	۲-	-
	${f -}$	Bending				Bend		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa		-	Over/Under	<u> </u>	Temperature/Cure
		Cracks			_	Broken/Damaged	\vdash	4	on Incomplete		Part Incorre	<u> </u>	Weld
	\vdash	Crushed/	Crimped.			Burrs	-	-	ions Incomplete/Unclear	<u> </u>	Part Lost/M	issing	Wrong Stock Pulled
·	\vdash	Cuffs			<u> </u>	Contamination	_	Mainte		\vdash	Part Moved		
	\vdash	Heat Trea			_	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		
	\vdash	Inspectio	,	Tube		Cut Too Short	<u> </u>	Misread	I		Power Loss/	Surge	Other
	l I	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

97937

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Start Date: 3/07/13

Required Date: 3/12/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	207.0000	6	6 //	1/94	1858	- SF
				Location		Loc Qty	Lo	c Code			·		٠,
	•			GA		37							
				122	2800	37					•		
				ST351		82							
				124	4221	82							
•				ST512		88							
				122	2800	88							
AN960JD8 Washer	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	² /7	1/232	48	<i>p</i>
D2581 Mounting Bracket		Manufactured	No			100	Each	54.0000	2	2	CC,	13-4-	.17
•				Location		Loc Oty	Lo	oc Code			•		
				WA004		54	R 0011	10	_> ()	(25)			
					766	2	D7010	10					
					253	, 1							
				82:	506	2							
		*			230	3							
					452	2							
					706 574	2							
					574 871	14					•		
					204	26							
D2931 Bumper		Manufactured	No			150	Each	2,264.0000	2	Sor	3-4-	<u>J3</u>	
·				Location		Loc Qty	Le	oc Code		~ \			
				GA	•	266							
					064	266 266			-	<u> </u>			
				ST021		1998	,						
					435	1998							

NICD.	Voc	1	NIa
NCR:	Yes	/	No

DQA: Date:

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	PDATE			
									QA Closed:	Date	
Work Orde	r:				DISPOSITION		-	AGAINST DE	PARTMENT	/PROCESS	
	··				Rework	7 l	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o				Work Order Update]	Large Fab	Composite]	Supplier	
		T-	 		<u>l</u>				- C: O	T	
Root					ption of work order update	Initial	1	ction	Sign &		061
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	Desc.	cription	Date	Verification	QC Inspector
Doc/Data	_										·
Equip/Tooling											
Operator		ļ									
Material											
Setup											
Other Process											
Supplier	-										
Training	7										
Jnapproved	*	``									
	······································			·	F	AULT CAT	GORY				
Landir	g Gear		;~		General				_		
[Bending				Bend	Grain			Ovalized		Pressure/Forced
. [Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks	100			Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs		•		Contamination	Maint	enance		Part Moved		
	Heat Trea	at			Countersink	Mislab	eled		Positioned \	Nrong _	
	Inspectio	•	Tube		Cut Too Short	Misrea			Power Loss/	/Surge	Other
ļ	Ripples in				Drill Holes	Offset			·		
Ĺ	Torque W	/aves in E	xtrusio	ո	Drawing	\vdash	Calibration				
	Turning S	equence			Finish	Out of	Sequence				
ĺ	Wave/Tw	ist in Tul	oe e	1	Folio	Outsid	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-01-13 1:51:12 PM

Work Order ID:	97937								•
Parent Item:	D3913-041						Start I	Date: 3/07/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Base A	Assemby, 350					Start	Qty: 1.00	Required Qty: 1.00
D3913-1 Rib		Manufactured	No		100	Each	5.0000	1	1 CC 13-4-17
				<u>Location</u> WA	Loc Qty	1B94	Loc Code 876 ~	- @	
				87541		!			· · · · · · · · · · · · · · · · · · ·
				WA004 88638	•	3			<u> </u>
				WA005 87543		1 1			·
D3913-15 Wide Handle Plate		Manufactured	No		100	Each	12.0000	1	1 EC 13-4-17
				Location	Loc Qty		Loc Code		
				. 90084 94153	1: 	2 4 2		- Gu	
				94272 94317		2 2 4			/
D3913-3 Rib		Manufactured	No		100	Each	6.0000	1	1 ((13-4-17
				Location WA005	Loc Oty	6 B94	Loc Code 1825 —	- (x	2
				69160 84651 94701		i 1 4		,	
D3913-7 Rib		Manufactured	No		100	Each	17.0000	2	2 ((13-4-17
,				Location	Loc Oty		Loc Code		
				WA005 88492	1			(Zx	
				95141		3			/

NCR:	Yes	/ No				WORK ORDER NON-O	COL	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
INCK	NO					Work Order Opdate	ן נ		raige rab	Composite		Jupplie!	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator	Ш					•							
Material	Ш												
Setup	Ш												
Other	Ш]								
Process	Ш			İ .									
Supplier	Ш				· `				ŕ		1		
Training	Ш												
Unapproved			Ì	<u> </u>									<u> </u>
						F	AUL	T CATE	GORY				
Landi	ng G	iear		•		General		,			1	_	- 1
	Ш	Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	O/S	BOM/Route	_	Hardwa			Over/Under	} 	Temperature/Cure
	Ш	Cracks				Broken/Damaged		4	ion Incomplete		Part Incorre	ct	Weld
	Ш	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Ш	Cuffs			Ľ	Contamination		Mainte			Part Moved		
	Ш	Heat Trea	it			Countersink		Mislabe	eled		Positioned V		
	Ш	Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ш	Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	Extrusio	n 🗍	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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March-01-13 1:51:12 PM

Work Order ID:	97937	,	12/1 13/1								
Parent Item:	D3913-041						Sta	rt Date:	3/07/13	Requir	ed Date: 3/12/13
Parent Item Name:	Long Basket Base Assemby, 350						St	art Qty:	1.00	Requi	red Qty: 1.00
D3913-9 Hinge Rib	Manufactured	No			100	Each	9.0000		1	1 00	13-4-17
			Location		Loc Qty	<u>′</u>	Loc Code				
			WA 94814 WA005	^d		5 5 4		•		- 	
			70138			1				_	
			88215 94512			1 2				_	
D3916-041 Rib Assembly	Manufactured	No	74312		100	Each	6.0000	,	2	² CC	13-4-17
Telo / tosemoly			Location		Loc Oty	,	Loc Code	•		1	
			WA005			6 B 94	1818 -	_	(zx)		
			81444			2	0,0	_		_	
			94093			4			•	_	
D3916-5 Light Rib	Manufactured	No			100	Each	23.0000		3	³ CC	13-4-17
			Location		Loc Qty	<u>.</u>	Loc Code		(5)	-	
			WA004			8 B99	1698 -		·_(3 <i>K)</i>	_	
			94163 94824			4 *				_	
			WA005			5				_	
			77142			1				_	
	~		82933			4	•			_	
D4016-1 Hinge Half, Base	Manufactured	No	·		100	Each	29.0000	•	3	³ CC	13-4-17
			Location		Loc Qty	4	Loc Code			٠	
			WA005		2	9 B 99	1098 -	`	<u> (3x)</u>		7
			93117			6	•				
			94481		2	23				_	
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as / Na				WORK OPDER NON-O	ONEOD	MANICE / LIDE	NATE	DQA:	Date:	
52 / INO				WORK ORDER NON-C		WANCE / OF E)AIL	QA Closed:	Date:	
				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
				Rework Scrap Use-as-is Work Order Update	Ther	~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~	Crosstube Small Fab Finishing Composite	ł		Engineering Quality Other
1	1		Descri	tion of work order update	Initial	Act	ion	Sign &		
Date	Step	Qty		•	Chief Eng	Descr	iption	Date	Verification	QC Inspector
		r			AULT CAT					
Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V Turning S	Crimped at n Strip in n Bend Vaves in E sequence	Tube extrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Hardw Inspec Instruct Maint Mislab Misrea Offset Out of	are tion Incomplete ctions Incomplete/U enance eled id Calibration Sequence		Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date Gear Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V Turning S	Date Step Date Step Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E Turning Sequence	Date Step Qty Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Description Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Oty Description of work order update or Non-conformance General Bending Bend BoM/Route Broken/Damaged Burrs Cracks Broken/Damaged Burrs Contamination Countersink Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence District Turning Sequence Drawing Finish	DISPOSITION Rework Scrap Use-as-is Work Order Update Or Non-conformance Initial Chief Eng Sear General Bending Bend Grain Hardw Cracks Broken/Damaged Inspection Strip in Tube Cut Too Short Misrae Ripples in Bend Drawing Torque Waves in Extrusion Turning Sequence There are signed as a signer or Non-conformance Order update or Non-conformance Initial Chief Eng Order Non-conformance Order Eng Order Inspection Strip in Tube Cut Too Short Misrae Offset Torque Waves in Extrusion Turning Sequence Finish Out of Ou	DISPOSITION Rework Scrap Machining Thermoforming Large Fab Date Step Qty Description of work order update Initial Act Chief Eng Description of work order update Chief Eng Description of work order update Initial Act Chief Eng Description of work order update Initial Act Chief Eng Description of work order update Initial Act Chief Eng Description of work order update Initial Act Chief Eng Description Description of work order update Initial Act Chief Eng Description De	DISPOSITION Rework Scrap Use-as-is Work Order Update Use-as-is Us	DISPOSITION Rework Skid-tube Crosstube Small Fab Pro Rec/Stor Composite DISPOSITION Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor.	

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March-01-13 1:51:13 PM

Work Order ID: 97937 D3913-041 **Start Date: 3/07/13** Required Date: 3/12/13 Parent Item: Long Basket Base Assemby, 350 Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: D4017-7 No 100 Each 13.0000 Manufactured CC 13-4-17 Rib Loc Qty Location WA004 WA005 69730 82969 85435 88392 2°CC 13-4-17 D4017-9 100 9.0000 No Each Manufactured Rib Location Loc Qty WA005 70341 81445 89395 100 D4020-11 17.0000 Manufactured No Each End Mesh, Basket Location Loc Qty Loc Code WA007 81442

96486

												DQA:	Date:	
NCR:	'es	/ No					WORK ORDER NON-C	O	NFOR	MANCE / UPI	DATE			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~
							-					QA Closed:	Date:	
Nork Orde	or.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIG							Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.		٠				Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR N	10.				F X		Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root	_				Des	crin	ntion of work order update		nitial	Act	ion	Sign &		
Cause	١	Date	Step	Qty			r Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
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quip/Tooling					İ									
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								AUL	T CATE	GORY				
Landi	\neg				ı		General	$\overline{}$	ارسن			Ovalized	_	Pressure/Forced
	\vdash	Bending			0 /5	$\overline{}$	Bend BOM/Barra	\vdash	Grain		 	Over/Under	toloranco	Temperature/Cure
	_	Centre No	ot Concer	itric to	0/5		BOM/Route Broken/Damaged	\vdash	Hardwa	ire ion Incomplete	 	Part Incorre	_	Weld
	\dashv	Cracks Crushed/0	C				Burrs	\vdash	4	tions Incomplete/l	Inclose	Part Lost/M		Wrong Stock Pulled
	_	Cuffs	crimpeu. •	•			Contamination	-	Mainte		Officieal	Part Moved		
	-	Heat Trea	ı +			_	Countersink	-	Mislabe		<u> </u>	Positioned V	Vrong	
	\dashv	Inspection		Tube			Cut Too Short	\vdash	Misrea		-	Power Loss/		Other
	\dashv	Ripples in		. 450		-	Drill Holes		Offset		<u>L</u>	-i	~ <u>_</u>	
	\dashv	Torque W		xtrusio	n		Drawing		-{	Calibration				
		Turning S					Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

March-01-13 1:51:13 PM

Work Order ID:	97937						6.	2/07/12	2/12/12
Parent Item:	D3913-041							Date: 3/07/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Base A	Assemby, 350				•	Start	Qty: 1.00	Required Qty: 1.00
D4021-1 Handle Plate		Manufactured	No	·	100	Each	44.0000	3	3 CC 13:4-17
				Location	Loc Qty		Loc Code		
				WA004	44	ļ			
				88323	2				
				88849	10)			<u> </u>
				89204	12	!			
				94596	3				
				94597	2			- 6	•
				95039	15			(3×	9
D4021-5 Blanking Plate		Manufactured	No		150	Each	25.0000	2	2 CC 13-4-17
				Location	Loc Qty		Loc Code		
				ST084	25	20	3187	 	
				85065	2	!	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
				89059	23	}		_===	BL 13-4-33.
D4034-041		Manufactured	No		100	Each	5.0000	1	1 /2 /3 //3
Aft Upper Rib Assembly									_ bl 18-4-33. 1
				Location	Loc Qty		Loc Code	~	
				WA005		69	3187 —	_> (IX)
				84048	1	UI.			<u></u>
				92806	3	,			
				WA006	1			•	
				94048	1			7	
D4034-043		Manufactured	No		100	Each	6.0000	1	
Fwd Upper Rib Assembly	v	Manaractarea			•				CC 13-4-17
				Location	Loc Qty		Loc Code		· · · · · · · · · · · · · · · · · · ·
					<u>Loc Qty</u>	B94	11190	-> (X)	
				WA004 97806	3		4/0		MARKET TO THE PARTY OF THE PART
					•				· · · ·
				WA005 82980	3				<u> </u>
				82980 94960	2				
				24700				-	<u> </u>

NCR:	Yes	/	No

WORK ORDER NON CONFORMANCE / LIDDATE

DQA: _____ Date: _____

NCR: Y	es / No				WORK ORDER NON-	CONFORI	VIAINCE / UPL	JAIE	QA Closed:	Date	<u>;</u>
Work Orde	r·		٠.		DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap	∤ I	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0	·	 ,		Use-as-is Work Order Update	-4 1	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descr	ription of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material											
Setup								•			
Other											
Process											
Supplier											
Training											
Unapproved											
					F	AULT CATE	GORY				
Landin	g Gear			``	General			_	-	_	
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardwa		_	Over/Under	⊢	Temperature/Cure
	Cracks				Broken/Damaged	—	ion Incomplete		Part Incorre	-	Weld
	Crushed/	Crimped			Burrs	⊢	tions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			_	Contamination	\blacksquare	enance	<u></u>	Part Moved		
	Heat Trea				Countersink	Mislabe		<u> </u>	Positioned V		
	Inspection		Tube	· [-	Cut Too Short	Misrea	t	L	Power Loss/	Surge	Other
	Ripples in			<u> </u>	Drill Holes	Offset				·····	
Ĺ	Torque W			n _	Drawing	⊢	Calibration				
	Turning S				Finish	⊢	Sequence			·	
	Wave/Tw	ist in Tul	эе		Folio	Outside	e Dimensions				

March-01-13 1:51:13 PM

Work Order ID: Parent Item: Parent Item Name:	97937 D3913-041 Long Basket Base Asse	emby, 350							Date: 3/07/13 'Qty: 1.00		_	l Date: 3/12/13 d Qty: 1.00
D4672-1 Blanking Plate	Ĭ.	Manufactured	No			100	Each	28.0000	2	2	CC	13-4-17
4				Location		Loc Oty		Loc Code				
				WA005		28						
				88253		6				•		
				94069		9			6	-		
				94551)	13			(2			
M304EX0.75-16F Expanded Metal Flat SS	Ĭ	Purchased	No	-		100	sf	641.7651	33	33	11	13-4-1
				Location		Loc Qty	Λ	Loc Code	1			
				WA		320.0000637	K12	35//3 -	<u>3</u> دــ	<u> </u>		
				124070		0.00006372	DI					
				124466		320				t		
				WA007		321.765						
				122534		160			<u> </u>			
		•		123448		108.16						
				124347		53.605						
MS20600-AD4W3	F	Purchased	No			150	Each	1,363.0000	2	2	50	13-4-2
Cherry Rivets		.*						Ť	- +	•	OY	
				Location		Loc Qty	•	Loc Code				
				ST311		1230						
				122151		10		ş.	. —			
				122452		7		, and the second				
				123525		313		j. se s		<u></u>		
				124231		900		**	<u> </u>			
	•			WA003		133			•			
				107939		133						

													DQA:	Da	te: _		
NCR:	Yes /	No				WORK ORDER NON-	100	NFORM	MANC	E / UP	DATE		QA Closed:	Da	to:		
			-2			DISPOSITION			.•		ACAINST			······································	te.		
Work Ord	er:					DISPOSITION					AGAINST	DEI	PARTMENT/	PROCESS			
						Rework]		Skid-tu	<u> </u>	Crosstube	-	_	Water Jet	П	Engineering	
Part I	No					Scrap		1	Machini	~ <u></u>	Small Fab	-		d. Eng. Coor.	\vdash	Quality	
NCD	N 1 -					Use-as-is		1	noformi	·	Finishing	-	Rec/Stor	e/Packaging	${f H}$	Other	
NCR I	NO					Work Order Update	ا ز		Large F	ab	Composite	لــــا		Supplier	ш.		
Root					Descri	ption of work order update		Initial		Act	tion		Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	,	Desc	ription	İ	Date	Verification	n	QC Inspector	
Doc/Data							T										
Equip/Tooling																	
Operator																	
Material	Ш				1												
Setup	Ш																
Other	Ш																
Process																	
Supplier	Ш				:							1					
Training	Ш																
Unapproved	<u> </u>	·					L										
			•				<u>AUI</u>	LT CATE	GORY								
Landi	ng Gea					General		7					1		$\overline{}$		
		nding				Bend	\vdash	Grain				<u> </u>	Ovalized		_	Pressure/Forced	
	\vdash		t Concer	tric to	o/s	BOM/Route		Hardwa					Over/Under		-	Temperature/Cure	
	\vdash	acks				Broken/Damaged		-l `	ion Incor	-		\vdash	Part Incorred		-	Weld	
	⊢		rimped.		<u> </u>	Burrs	_	4		omplete/	Unclear	<u> </u>	Part Lost/Mi	ssing		Wrong Stock Pulled	
	∐ Cu	ffs				Contamination	\vdash	Mainte	enance			$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Part Moved				
	He	at Treat			[Countersink	1	Mislabeled					Positioned Wrong				

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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March-01-13 1:51:13 PM

Work Order ID: Parent Item:	97937 D3913-041						ate: 3/07/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Base Assemby,	350				Start (Qty: 1.00	Required Qty: 1.00
MS21042L3 Nut	Purcha	ased No		150	Each	6,721.0000	6	6 Sp.
		Loca	ation_	Loc Oty		Loc Code		•
	•	FP00	01	3				
			122141	3				
		GA		296				
			122452	296				
		ST3	14	268				
			117885	32				
			119017	55				
			119075	138				
			123265	43				
		ST50		6154				<u> </u>
			123900	2154				
			124291	4000				2K_
NAS1149F0332P WASHER	Purcha	ased No		150	Each	10,520.000	12	5013-4-23.
		Loca	ation	Loc Qty		Loc Code		•
		GA		194				·
			122063	194		r*		
		ST2	94	323				
			122063	323				
		ST2	95	3				
			123352	3				· ···
		st51		10000				•
			123900	10000				X
				•				

											DQA:	Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDAT	Ε				
		•									QA Closed:	Date	e:	
Work Ord	or:					DISPOSITION			A	GAINST DEI	PARTMENT	PROCESS		
WOIK OIG	C1.					Rework	1		Skid-tube Cr	osstube		Water Jet		Engineering
Part I	VIΩ					Scrap	1		—	mall Fab	Pro	d. Eng. Coor.	ᅦ	Quality
, uit	•0.					Use-as-is			~ —	inishing		e/Packaging		Other
NCR	No.					Work Order Update	1		· · · · · ·	mposite	·	Supplier		
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification		QC Inspector
Doc/Data														
Equip/Tooling													ı	
Operator	L_						Ì							
Material														
Setup														
Other	<u> </u>										,			
Process														
Supplier														
Training				•										
Unapproved			<u> </u>											
							AUL	T CATE	GORY				,	
Landi	ng (7			_	General	_	1			1	Г		
	<u> </u>	Bending				Bend		Grain			Ovalized	1		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u>_</u>	Hardwa		<u> </u>	Over/Under	-		Temperature/Cure
		Cracks			<u></u>	Broken/Damaged	<u></u>	4 `	on Incomplete	<u> </u>	Part Incorre	· -		Weld
	$ldsymbol{ld}}}}}}$	Crushed/	Crimped.			Burrs	L_	4	ions Incomplete/Unclea	ar	Part Lost/M	ssing		Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance		Part Moved			
		Heat Trea	it			Countersink		Mislabe	led		Positioned Wrong			1
		Inspection	n Strip in	Tube		Cut Too Short		Misread	ł	Power Loss/Surge			Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

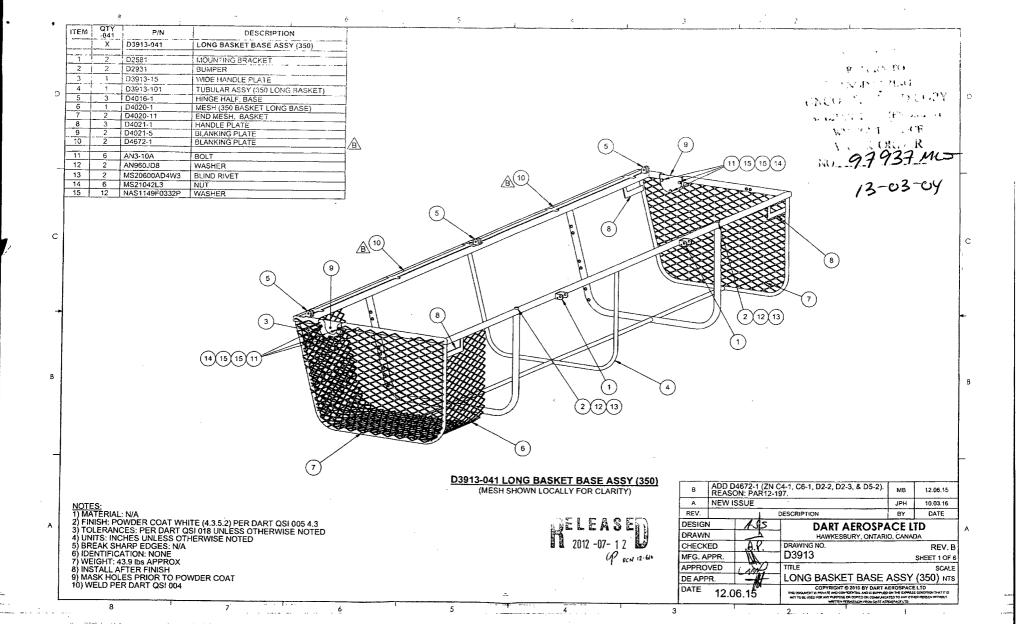
Torque Waves in Extrusion

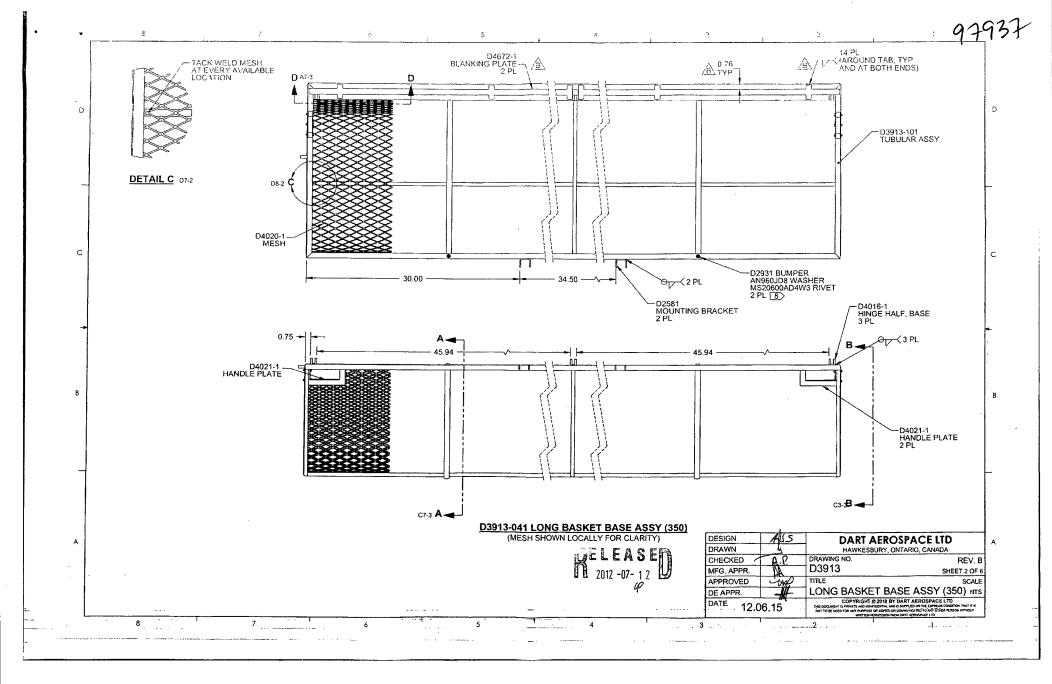
Drill Holes

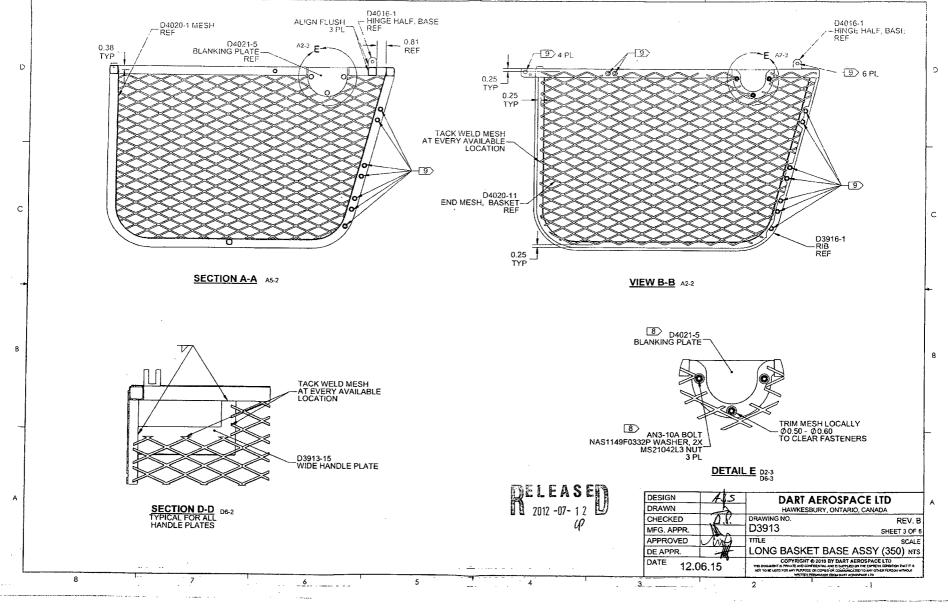
Drawing

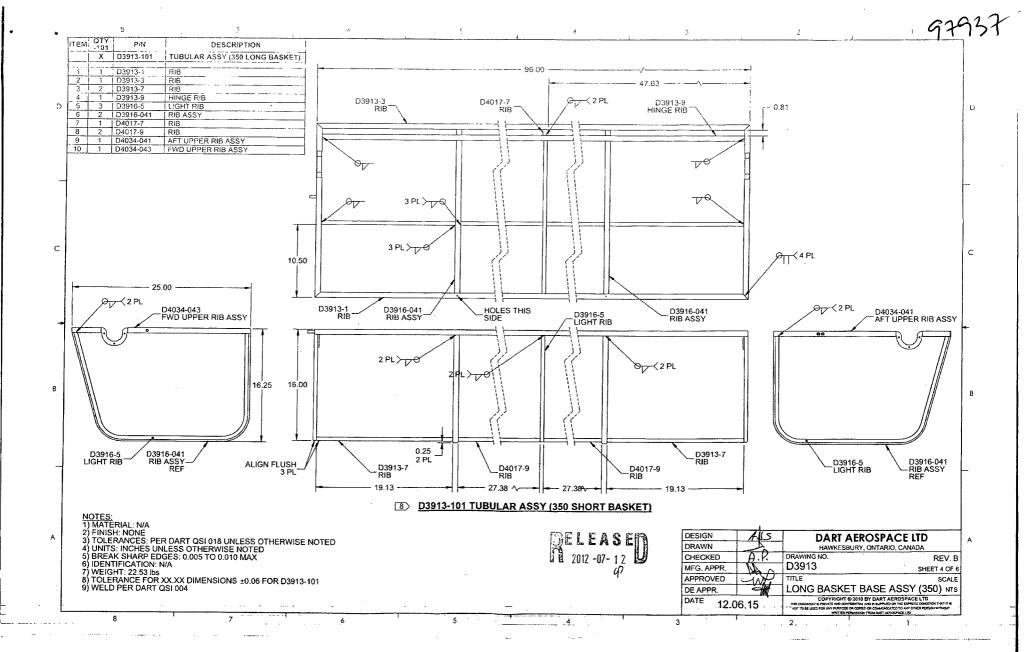
Finish

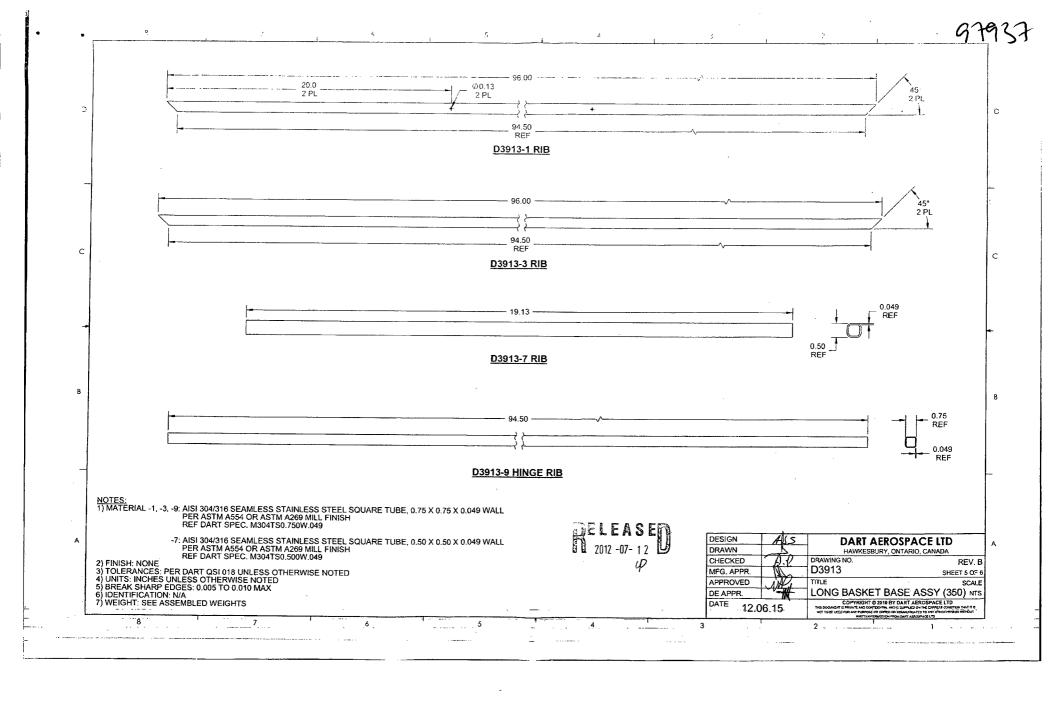
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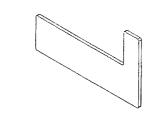


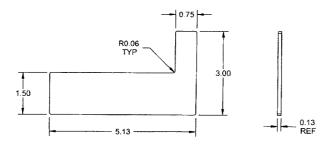












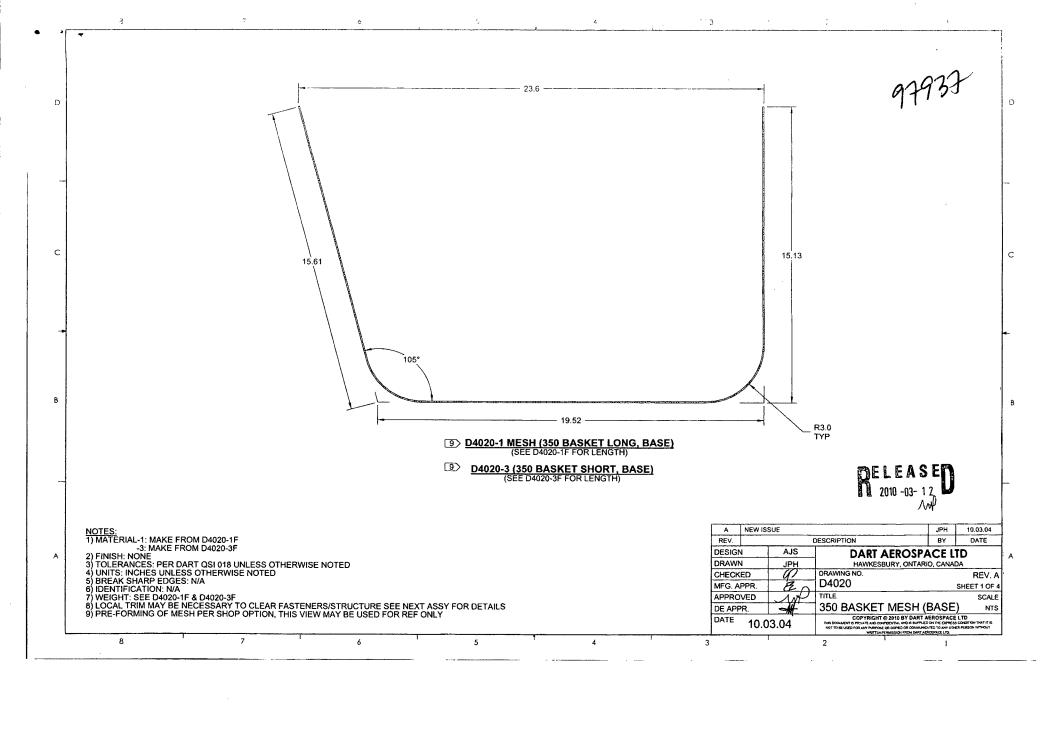
D3913-15 WIDE HANDLE PLATE

С

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

2012 -07- 12

DESIGN DRAWN	1.5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECKED	A.V.	DRAWING NO. REV. B							
MFG. APPR.	M	D3913 SHEET 6 OF 6							
APPROVED	INT	TITLE SCALE							
DE APPR.	4	LONG BASKET BASE ASSY (350) NTS							
DATE 12.0	6.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CHESTION AND IS SEPACED OF THE COPYESS CONSTITUTION AND IT TO BE USED TO ANY OTHER PRISON WITHOUT — WRITTEN POWER DAY DAY TO BE AND IT TO ANY OTHER PRISON WITHOUT — WRITTEN POWER DAY DAY TO BE AND IT TO ANY OTHER PRISON WITHOUT —							



D4020-5: 95.25 D4020-7: 56.00 D 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) D4020-7 MESH (350 BASKET SHORT, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

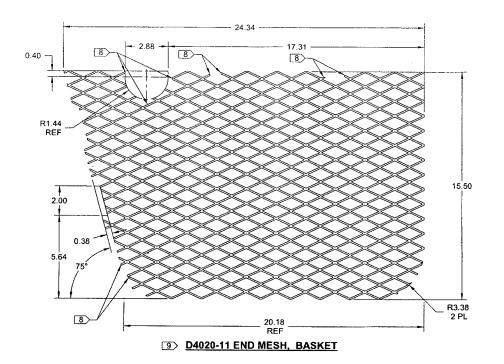
6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX

-7: 4.49 lbs APPROX

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F 2) FINISH: NONE

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2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 Ibs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

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3

